

SPLIT

Work Order ID 68724-1

Wednesday, April 20, 2011 10:22:41 AM



Page 1

Item ID: D4292-1

Accept



Setup Start



Revision ID:

Item Name: Fitting

Stop



Start Date: 4/20/2011 Start Qty: 4.00

Required Date: 4/25/2011 Req'd Qty: 4.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date: 11-04-20 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4292

C

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut Blank to 6.250"

Batch: 1116930

\*\*\*\*GRAIN DIRECTION MUST BE ALONG 4.00"\*\*\*\*\*

11/06/21

4

9

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine per folio FB002

DWG REV: C

FOLIO REV: AA

LA 11/06/22

2

φ

2- deburr rough edges

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Reference:

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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

G.A 11/06/22

2

0

121



Mill Conv

Conventional Milling Machine

Memo

DRILL & TAP FOR HELICOIL AS PER DWG

0.00

0.00

OK 11/06/22

2

0

122



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

OK 11/06/22

2

0

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Customer:

Reference:

Run Start



Approvals:

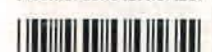
Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC8- Inspect parts - second check

0.00

22 11/06/23



QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

2 BL 11-6-23

145

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

MASK THREADED HOLE

Start Time: 9:15  
Temp: 320 °F  
Finish Time: 9:45

2x Ø m-f 11/06/23

M 116964

W/O:		WORK ORDER CHANGES					
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Reference:

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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

2 BR 11-6-23

151

0.00



Small Fab

Memo

0.00

Small Fab

INSTAL HELICOIL

g511/06/23 (2)

152

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8 u66/73

(+2)

-1

W/O:		WORK ORDER CHANGES					
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**Work Order ID 68724**

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Page 5

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Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180



Packaging

Identify as per dwg & Stock Location: ST481

0.00

Memo

0.00

Packaging

W 11-06-23 (2)

190



QC

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Quality Control

11/06/23MF11-06-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, April 20, 2011 10:22:47 AM

Page 1

Work Order ID: 68724

Parent Item: D4292-1

Parent Item Name: Fitting



Start Date: 4/20/2011

Required Date: 4/25/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 10-11-14 JLM VERIFIED BY:DD IPP REV  
B: AS PER REV B 11-02-15 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M7075T73B4.000x4.00 0		Purchased	No			100	f	19.1210	0.52	2.189474			



7075-T73 Bar 4.0 x 4.0



Location	Loc Qty	Loc Code
MAT005	19.121	
116153	0.75	
116324	7.95	
116764	6	
116867	0.041	
116930	4.38	

MS21209F1-10

Purchased

No

Each

92.0000



HELI COIL



Location	Loc Qty	Loc Code
ST305	92	
116977	92	

2.18 OK 11/06/21  
4  
9511/05/23  
2

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 68724
<b>Description:</b> FITTING		<b>Part Number:</b> D4292-1
<b>Inspection Dwg:</b> D4292	<b>Rev:</b> C	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R0.063	+/- .010	R0.063	✓		R-6	ref.
0.250	+0.030/-0.010	0.259	✓		Vern	GA-01
0.125	+0.030/-0.010	0.131	✓		"	"
2.95	+/-0.030	2.955	✓		"	"
0.275	+/-0.010	0.275	✓		"	"
0.800	+/-0.010	0.800	✓		"	"
0.825	+/-0.010	0.825	✓		"	"
0.375	+/-0.010	0.374	✓		"	"
0.31	+/-0.030	0.312	✓		"	"
0.88	+/-0.030	0.884	✓		"	"
0.663	+/-0.010	0.661	✓		"	ML-7
φ0.381	+0.000/-0.001	0.381	✓		"	"
1.125	+/-0.010	1.125	✓		"	"
1.063	+/-0.010	1.063	✓		"	"
3.44	+/-0.030	3.438	✓		Vern	GA-01
2.450	+/-0.010	2.450	✓		"	"
1.325	+/-0.010	1.326	✓		"	"
0.300	+/-0.010	0.301	✓		"	"
1.200	+/-0.010	1.200	✓		"	"
2.84	+/-0.030	2.835	✓		"	"
0.19	+/-0.030	0.191	✓		"	"
5.86	+/-0.030	5.864	✓		"	"
5.99	+/-0.030	5.992	✓		"	"

<b>Measured by:</b> B.A. /mg	<b>Audited by:</b> J.L.	<b>Preliminary Approval:</b>
<b>Date:</b> 11/06/22	<b>Date:</b> 11/06/23	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 68724
<b>Description:</b> FITTING		<b>Part Number:</b> D4292-1
<b>Inspection Dwg:</b> D4292 <b>Rev:</b> C		<b>Page</b> 1 <b>of</b> 1

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
φ 0.272	<del>φ 0.272</del> <sup>+0.006</sup> / <sub>-0.001</sub>	φ 0.273	✓		Vern	GA-01
φ 0.266	<del>φ 0.266</del> <sup>+0.006</sup> / <sub>-0.001</sub>	φ 0.268	✓		"	"
1.75	+/- .030	1.754	✓		"	"
R 0.25	+/- .030	R 0.250	✓		R-G	ref.
R 0.06	+/- .030	R 0.063	✓		"	"
4.875	+/- .010	4.875	✓		Vern	GA-01
0.493	+/- .010	0.495	✓		"	"
CORE φ 0.765	+/- .010	φ 0.766	✓		"	"
0.250	+0.030/- .010	0.252	✓		Mic	GA-03
0.680	+/- .010	0.680	✓		Vern	GA-01
2.250	+/- .010	2.251	✓		H-G	31006
4.500	+/- .010	4.501	✓		Vern	GA-01
R 1.275	+/- .010	R 1.275	✓		R-G	ref.
R 0.031	+/- .010	R 0.032	✓		"	"
R 0.13	+/- .030	R 0.125	✓		"	"
1.65	+/- .030	1.655	✓		Vern	GA-01
1.421	+/- .010	1.421	✓		"	"

<b>Measured by:</b> B.A./mz	<b>Audited by:</b> SL	<b>Preliminary Approval:</b>
<b>Date:</b> 11/06/22	<b>Date:</b> 11/06/23	<b>Date:</b>

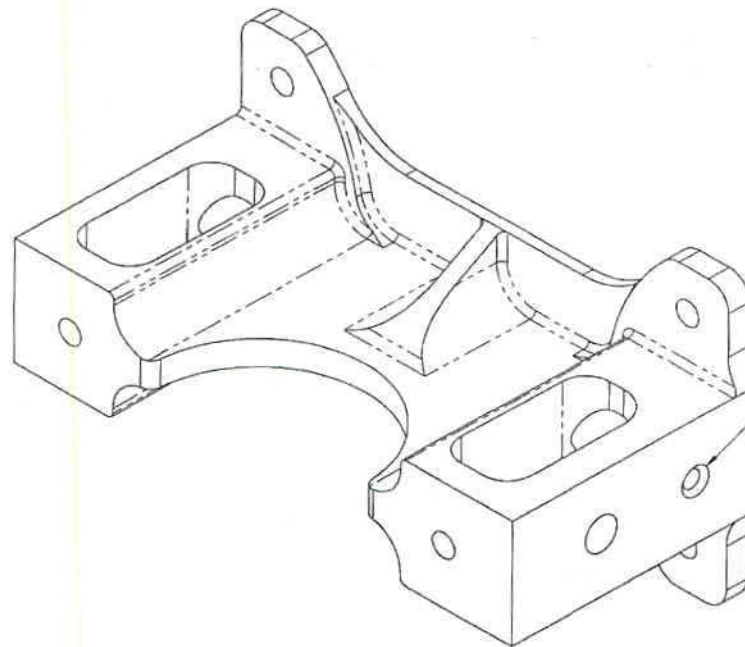
Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15

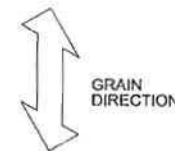


SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 48724

*PH-04-20*



MS21209F1-10 HELICAL COIL, 1X  
REF



**D4292-1 FITTING**

RELEASED  
2011-02-01

**NOTES:**

- 1) MATERIAL: 7075-T73/-T7351/-T73510/-T73511 BAR  
PER AMS-QQ-A-200/11 OR AMS-QQ-A-225/9 (AMS 4124) OR AMS-QQ-A-250/12 (AMS 4078)  
REF DART SPEC. M7075T73B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: P/N "D4292-1" AND B/N PER DART QSI 044 8.1
- 7) WEIGHT: 1.02 lbs

C	1.064 WAS 1.235 (C1-2), Ø0.266 WAS Ø0.323 (B3-2), ADD HELICAL COIL (D1-2)	CP	10.12.23
B	0.800 WAS 0.78 (C6-2), 0.825 WAS 0.81 (C4-2)	CP	10.11.30
A	NEW ISSUE	CP	10.11.09
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>GP</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>GP</i>		
CHECKED	<i>GP</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>GP</i>	D4292	SHEET 1 OF 3
APPROVED	<i>GP</i>	TITLE	SCALE
DE APPR.	<i>GP</i>	FITTING (206L/407 FWD)	NTS
DATE	10.12.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSES OUTSIDE OF THE SPECIFIC PROJECT TO WHICH IT IS ISSUED WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	

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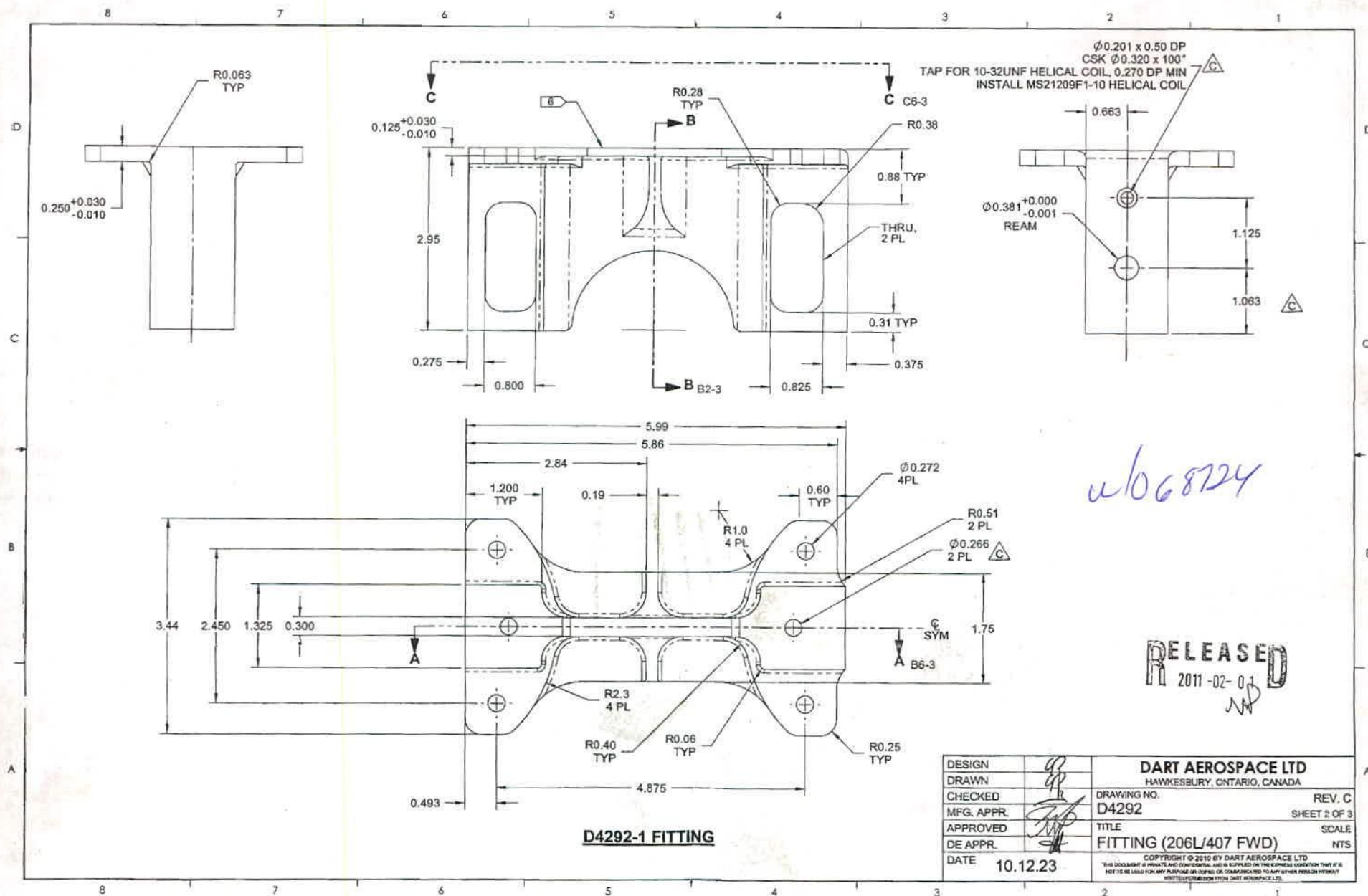
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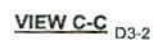
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RELEASED  
2011-02-01  
AMH

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4292	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		FITTING (206L/407 FWD)	NTS
DATE	10.12.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PROVIDED TO YOU BY DART AEROSPACE LTD ON THE CONDITION THAT IT IS NOT TO BE REPRODUCED OR COPIED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	

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